

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-024169**Date Inspected:** 27-May-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai,China**CWI Name:** Liu Hua Jie/Lv Li Qing**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Nagalingam Pandaram Pillai was present during the times noted above for observations relative to the work being performed.

Ultrasonic Testing:-

OBG Trial Assembly

This QA Inspector performed Ultrasonic testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as OBG Segment 13AW.The weld designation reviewed is as follows

SEG3013Q-261,235,268,267

SEG3013C-169

SEG3013G-099

SEG3013J-067

DP3120-015

SEG3013N-212,213,215

SEG3013AA-014

In process Inspection:-

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OBG Trial Assembly

This QA inspector observed the following work in progress:

SMAW welding of weld joint No: OBE13B-001 located on OBG Segment 13AE and 13BE Bottom panel Splice. Welder is identified as #043661. ZPMC QC is identified as Mr. Wang Li yang. Welding was performed according to the Critical weld repair report B-CWR-2992. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-1G(1F)-FCM-Repair-1.

This QA inspector observed the following work in progress:

SMAW welding of weld joint No: SEG3011H-078 located on OBG Segment 13CE Bottom panel Stiffener to Floor Beam. Welder is identified as #066258. ZPMC CWI is identified as Mr. Lv Li Qing. Welding was performed according to the weld repair report B-WR-21038. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-3G(3F)-FCM-Repair-1.

This QA Inspector observed the following work in progress:

SMAW in the 3G position for the OBG Segment 13CE Side panel stiffener to Floor Beam. The weld joint was designated as: SEG3011C-173. The welder is identified as #068924. ZPMC CWI is identified as Mr. Lv Li Qing. The welding variables recorded by QC appear to comply with WPS-B-P-2213-TC-U4B-FCM-1.

This QA Inspector observed the following work in progress:

FCAW in the 3G position for the OBG Segment 13CE Side Panel Stiffener to Floor Beam. The weld joint was designated as: SEG3011B-110. The welder is identified as #051359. ZPMC CWI is identified as Mr. Lv Li Qing. The welding variables recorded by QC appear to comply with WPS-B-T-2233-ESAB. Please see the attached picture.

This QA Inspector observed the following work in progress:

SMAW in the 4G position for the OBG Segment 14E Vertical Panel Stiffener. The weld joint was designated as: VP3016-001-007. The welder is identified as #067183. ZPMC QC is identified as Mr. Wang Li yang. The welding variables recorded by QC appear to comply with WPS-B-P-2214-TC-U4B-FCM-1.

Visual Inspection after Blast:-

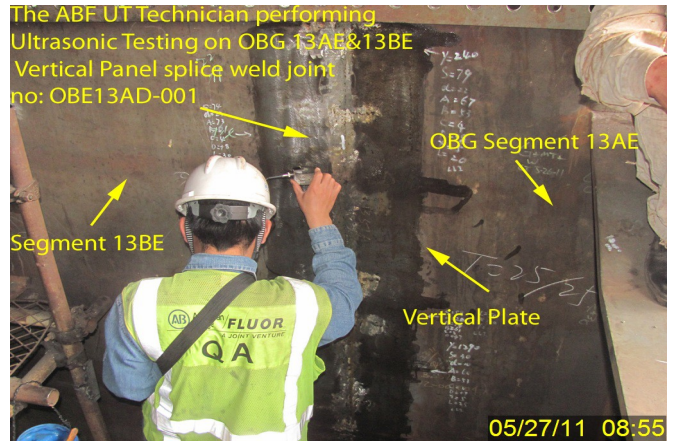
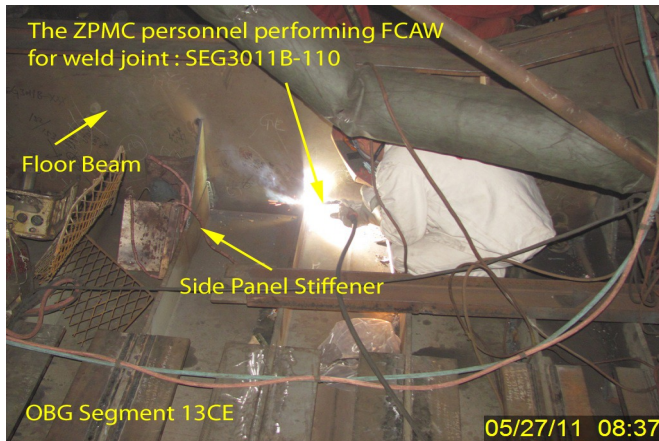
Segment 13AE

This QA Inspector performed a preliminary random visual inspection after the grit blast of the Edge panel and Deck panels at panel point 118.5 Cross Beam side of this segment. Areas of visual weld defects that will require welding were taped and will be repaired after the coating is applied. ZPMC QC personnel are aware of these areas and were present during the inspection.

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Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No Relevant Conversation.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By: Pillai,Pandaram

Quality Assurance Inspector

Reviewed By: Patel,Hiranch

QA Reviewer